

Work Order ID 145381

Thursday, May 05, 2016 3:23:20 PM

145381

Page 1

Item ID: D2322

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Spacer

Start Date: 5/20/2016 Start Qty: 18.00

18

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals: Process Plan: gm Date: 16/05/05 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2322	Rev C								

100

0.15

100

Waterjet

FLOW WATER JET

Memo

0.90

FLOW CNC Waterjet

1-Cut as per Dwg D2322 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(18)

De 16/06/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.18

Quality Control

(18)

De 16/06/10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.36

Quality Control

(18)

DAS
38

JUN 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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OTHER : _____																																																															

Thursday, May 05, 2016 3:23:20 PM

Page 3

DAS
21
9-89 JUL 14 2016

DQA: _____ Date: _____

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, May 05, 2016 3:23:24 PM

Page 1

Work Order ID: 145381

145381

Parent Item: D2322

D2322

Parent Item Name: Step Spacer

Start Date: 5/20/2016

Required Date: 6/3/2016

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	56.2110	0.203	3.846316			

M2024T3S 040

2024-T3 .040 sheet

DE 16 / 06 / 10

Location

Loc Qty

Loc Code

MAT022

56.211

m133548

6.74

m134157

0.4

m134399

1.971

m134532

47.1

M 134774

4.4

DQA: _____ Date: _____

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OTHER :																																																																									



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	MM	HAWKESBURY, ONTARIO, CANADA
DATE	98.09.29	TITLE	STEP SPACER	REV. C
	A		94.10.14	DRAWING NO.
	C		98.09.29	D2322
				SHEET 1 OF 1
				SCALE
				1:2
				CHANGES PER NCR 001
				4.428 WAS 4.460, 0.040 WAS 0.032
				NEW ISSUE

RELEASED
18.10.08 DS

UNDER REVIEW

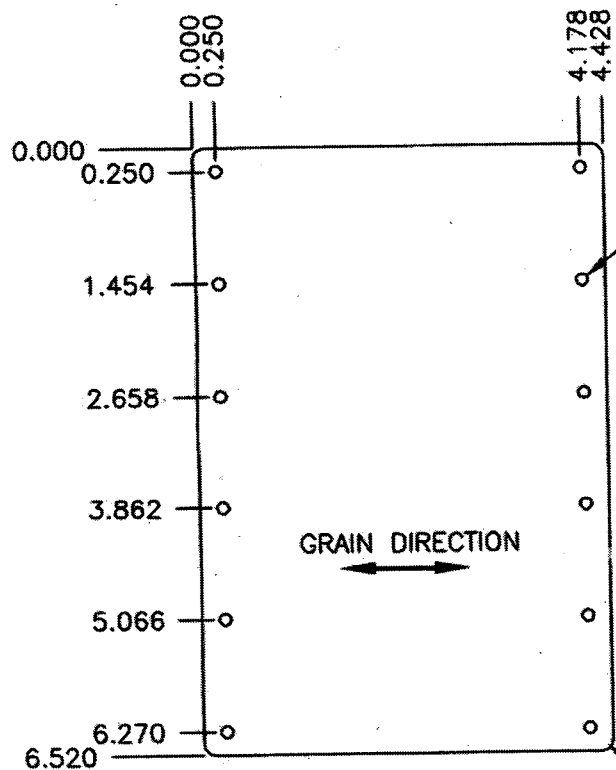
01.03.15 CP

DESIGN OK, BUT CHECK WITH
MFG BEFORE MANUFACTURE
OK CP 01/11/14

Re 98.09.29

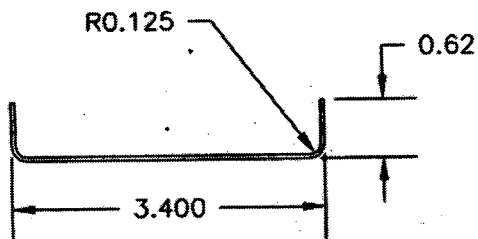
R0.125
(TYP 4 PLACES)

Ø0.128 (TYP 12 PLACES)



GRAIN DIRECTION

FLAT LAYOUT



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

w/o 145381

dm 16/05/05

